

Work Order ID 57390

April 6, 2010 10:52:48 AM



Page 1

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Item Name: Skidtube LH

Stop



Start Date: 06/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

RF

Date: *10-11-06*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 005

8

RF for BG 10/04/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end								
	2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.								
	3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.								
	4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"								
	5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)								
	7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	8-Open up holes of Detail A to 0.297" (total of 2 holes per side)								
	9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R <input type="checkbox"/> <input type="checkbox"/> Aluminum Rod <input checked="" type="checkbox"/> <u>M113207</u> BE 10/04/12								
	10-Grind welds flush as per Dwg D2750 BE 10/04/12								

10/04/12

BE 10/04/12

W/O:		WORK ORDER CHANGES					
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April 6, 2010 10:52:48 AM



Page 3

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

12- Scribe batch# inside per dwg D2750

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

S 10/04/13

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 10/04/13

70

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

1 11/10/14/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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April 6, 2010 10:52:48 AM



Page 4

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10-4-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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April 6, 2010 10:52:48 AM



Page 5

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3- Open float hole to 0.500" (4 per side)								
	4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8)								
	5-Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 batch: <u>M112429</u> exp. date: <u>10/31/30</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Aluminum Rod batch: <u>M113207</u>								
	9-Grind welds flush as per Dwg D2750								
	10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750								

M10/4/13

BE 10/04/14

BE 10/04/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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April 6, 2010 10:52:48 AM



Page 6

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Customer:

Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
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Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11- At section AJ-AJ drill out x-bolt spacer to 0.404"

3 BE 10/04/15

12-Debur holes

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8 10/04/15

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*8 10/04/15**40*

W/O:		WORK ORDER CHANGES					
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April 6, 2010 10:52:48 AM



Page 7

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

=> HU 10/04/19

(X1)

0

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 6:45am
OVEN TEMPERATURE: 320°F
FINISH TIME: 8:15pm

=> HU 10/04/20

1

0

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

BR 10-4-20

Q

W/O:		WORK ORDER CHANGES					
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April 6, 2010 10:52:48 AM



Page 8

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

220

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1- Install inserts as per Dwg D2750

10-4-20 ①

230

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: _____

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 112424

EXP DATE: 10/08

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: 104789

5-Coat all exposed fasteners with "LPS Procyon" batch: 1104251

10-4-20 ①

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April 6, 2010 10:52:48 AM



Page 9

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/04/20

Memo

0.00

(X)

250



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

10-4-20 SP

260



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

S 10/04/20

Memo

0.00

(X)

*****ensure antiseize is on AN8C21A bolts*****

W/O:		WORK ORDER CHANGES					
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April 6, 2010 10:52:48 AM



Page 10

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270



Packaging

Packaging

Packaging

Loc 12

Memo

Package as per PPP D350-636-011

0.00

0.00

Rev #

10-4-21 SP

280



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/04/21

mf

10-4-21

W/O:		WORK ORDER CHANGES					
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Picklist Print

April 6, 2010 10:52:52 AM

Page 1

Work Order ID: 57390

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
IPP Rev: J 06-03-23 As per Rev D JLM
IPP Rev: K 06-07.13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 06/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

D2594-3

Manufactured No

230 Each

268.0000 8.0000



O-Ring, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

55546 ✓

268

268

110 Each

42.0000 1.0000

D2744



Cap

Manufactured No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

42

47488

23

51922

19

110 Each

5.0000 1.0000

D2600-3-BENT



Extrusion Bent

Manufactured No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

5

55462

5

8 BR/3-H-20

1 4/10/12

1 4/10/12

W/O:		WORK ORDER CHANGES					
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April 6, 2010 10:52:52 AM

Page 2

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Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev: I ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No 160 Each 138.0000 8.0000



Crossbolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	138	
50281	50	
52310	88	

8 BE 10/04/14

D2739 Manufactured No 160 Each 2.0000 1.0000



350 I Beam

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	2	
55986	2	

1 11/04/13

D3490-3 Manufactured No 160 Each 40.0000 4.0000



Cross Bolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	40	
55010	40	

A

B 48276

3

1 BE 10/04/14
BE 10/04/14

April 6, 2010 10:52:52 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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April 6, 2010 10:52:52 AM

Page 3

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 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3490-1 Manufactured No 160 Each 12.0000 4.0000



Cross Bolt Spacer



Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG 12

51932 12

ALS4-1032-225 Purchased No 220 Each 7,729.000 38.0000



Insert



4 BE 10/04/14

Warehouse Loc Qty Loc Code
Location

Main Warehouse

PK011 7729

110768 7729

D3492-041 Manufactured No 230 Each 42.0000 8.0000



Plug Assembly



36 BL 10-4-20

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 42

55446 42

8. BL 10-4-20.

April 6, 2010 10:52:52 AM

Shop Packet Print

Page 3

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Page 4

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IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

10.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP19

10

55458 ✓

10

Purchased

No

230

Each

19.0000

1.0000

AN8C35A



BOLT

1 Bk 10-4-20.

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

19

110847 ✓

19

Manufactured

No

230

Each

14.0000

1.0000

D3793-1



Wearshoe

1 Bk 10-4-20.

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP18

14

51597 ✓

2

56300

12

1 Bk 10-4-20.

April 6, 2010 10:52:52 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 6, 2010 10:52:52 AM

Page 5

Work Order ID: 57390



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
IPP Rev: J 06-03-23 As per Rev D JLM
IPP Rev: K 06-07-13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3488-041

Manufactured No

230

Each

24.0000

1.0000



Blade Fitting Assembly, LH

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

24

47348 ✓

4

53915

20

1 Bl 10-4-20.

D3794-3

Manufactured No

230

Each

27.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

4

51907 ✓

4

Main Warehouse

FP18

23

56066

23

1 Bl 10-4-20.

April 6, 2010 10:52:52 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 6, 2010 10:52:52 AM

Page 6

Work Order ID: 57390



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev: I 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased No 230 Each 53.0000 4.0000



BOLT



Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

FG 2

103964 2

Main Warehouse

ST344 51

111605 1

111649 ✓ 50

MS21083C8

Purchased No 230 Each 50.0000 1.0000



NUT



Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST303 50

113845 ✓ 50

4 BR 10-4-20.

1 BR 10-4-20.

April 6, 2010 10:52:52 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 6, 2010 10:52:52 AM

Page 7

Work Order ID: 57390



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No 230 Each 12.0000 1.0000



Gasket



Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP10 12

54479 12

1 BL 10-4-20

D3631-1

Manufactured No 230 Each 302.0000 8.0000



Washer



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST076 302

52693 302

8 BL 10-4-20

D3791-1

Manufactured No 230 Each 18.0000 1.0000



Wearplate



Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 7

55457 7

Main Warehouse

FP17 11

56299 11

1 BL 10-4-20

April 6, 2010 10:52:52 AM

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 6, 2010 10:52:52 AM

Page 8

Work Order ID: 57390

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP Rev: I ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 06/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C10L



washer

D2745



Bushing

Purchased No 230 Each 0.0000 38.0000

Manufactured No 230 Each 150.0000 8.0000

114341
 NAS1149C0332R 113524

38. BL 10-4-20.

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST023

150

52311 ✓

150

AN3C5A



Bolt

Purchased No 230 Each 389.0000 34.0000

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST351

389

113121 ✓

10

114056 ✓

179

114108

100

114181

100

34. BL 10-4-20.

April 6, 2010 10:52:52 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 6, 2010 10:52:52 AM

Page 9

Work Order ID: 57390

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 06/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No 230 Each 51.0000 3.0000



Wearpad

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	FP	51	
	55465	51	

3 Bk 10-4-20.

AN960C816L Purchased No 230 Each 146.0000 1.0000



WASHER

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST348	146	
	110584	100	
	111424	46	

1 Bk 10-4-20

D3492-043 Manufactured No 230 Each 42.0000 8.0000



Plug Assembly

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	FP	42	
	54682	42	

8 Bk 10-4-20.

April 6, 2010 10:52:52 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 6, 2010 10:52:52 AM

Page 10

Work Order ID: 57390



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
IPP Rev: J 06-03-23 As per Rev D JLM
IPP Rev: K 06-07.13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

679.0000 4.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST351

679

111982 ✓

679

Purchased

No

230

Each

41.0000 8.0000

NAS1611-013



O-RING

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

41

113743 ✓

41

Manufactured

No

230

Each

5.0000 1.0000

D3535-25



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

5

56065 ✓

5

4 BR 10-4-20.

8 BR 10-4-20.

1 BR 10-4-20.

April 6, 2010 10:52:52 AM

Shop Packet Print

Page 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 6, 2010 10:52:52 AM

Page 11

Work Order ID: 57390

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 06/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

7.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

55459 ✓

7

7

MS21043-6

Purchased

No

230

Each

878.0000

4.0000



NUT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST301

112314 ✓

878

878

D3493-1

Manufactured

No

260

Each

19.0000

2.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST224

47710

19

19

1 Bl 10-4-20.

4 Bl 10-4-20.

10-4-20 SP

2

April 6, 2010 10:52:52 AM

Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 6, 2010 10:52:52 AM

Page 12

Work Order ID: 57390

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP Rev: I ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 06/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased No

260

Each

50.0000

2.0000



NUT

10-4-20 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST303

50

113845

50

AN8C21A

Purchased No

260

Each

99.0000

2.0000



BOLT

2

10-4-20 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST345

99

111605

49

113558

50

AN960C816L

Purchased No

260

Each

146.0000

2.0000



WASHER

2

10-4-20 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST348

146

110584

100

111424

46

2

2

April 6, 2010 10:52:52 AM

Shop Packet Print

Page 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 6, 2010 10:52:52 AM

Page 13

Work Order ID: 57390

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Date: 06/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

230

Each

1,589.000 4.0000



Phenolic Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST077

1589

47628

89

51674

500

52505

1000

Manufactured No

260

Each

11.0000 1.0000

D2741



Blade, 350 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST466

11

51931

11

Manufactured No

260

Each

51.0000 2.0000

D3532-1



Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST068

51

52321

51

4. BR 10-4-20.

10-4-2054

1

10-4-20 SD

2

April 6, 2010 10:52:52 AM

Shop Packet Print

Page 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 6, 2010 10:52:52 AM

Page 14

Work Order ID: 57390



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev: I ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
IPP Rev: J 06-03-23 As per Rev D JLM
IPP Rev: K 06-07.13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3672-13

Purchased

No

260

Each

920.0000 2.0000



Phenolic Washer



10-4-20 SV

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST077

920

54363

920

2

April 6, 2010 10:52:52 AM

Shop Packet Print

Page 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN6C35A	BOLT
38	38	38	38	AN96C10L	WASHER
1	1	1	1	AN96C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52390
AS 10-4-06

RELEASED
08-07-17

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL *A*
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL *A*

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN C8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWDRAFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN C8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H4L; REMOVE D2741; QTY (2) AN96C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DED 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24594-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PC</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>PC</i>	PORT HADLOCK, WA	
CHECKED	<i>PC</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>PC</i>	D2750	SHEET 1 OF 11
APPROVED	<i>PC</i>	TITLE	SCALE
DE APPR.	<i>PC</i>	350 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

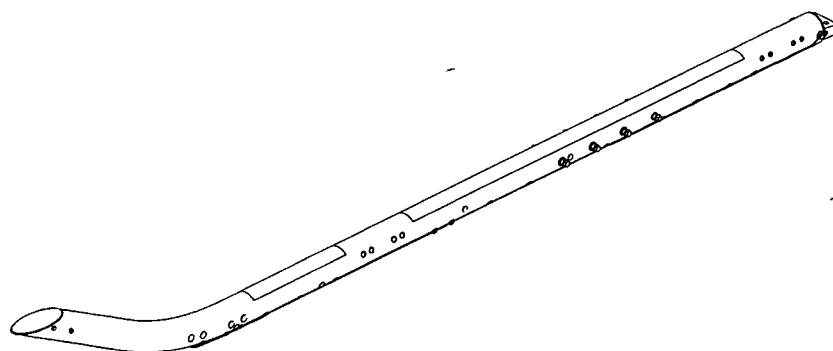
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

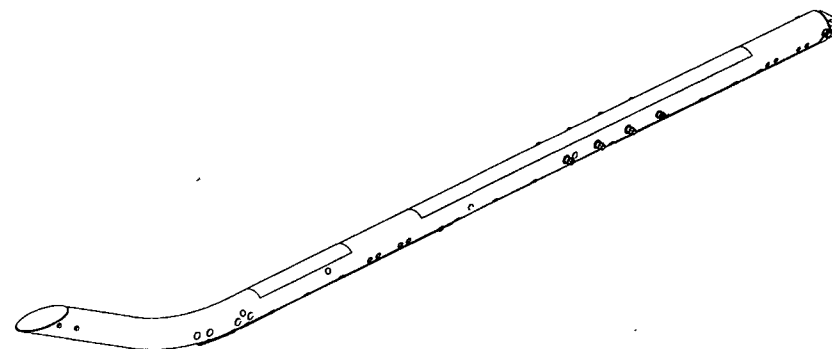
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

u/o 57390



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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1980-09-22/11

DESIGN	PC	DART AEROSPACE USA, INC.	
DRAWN	PM	PORT HADLOCK, WA	
CHECKED	JA	DRAWING NO.	REV. F
MFG. APPR.	DA	D2750	SHEET 2 OF 11
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DE APPR.	MA	350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

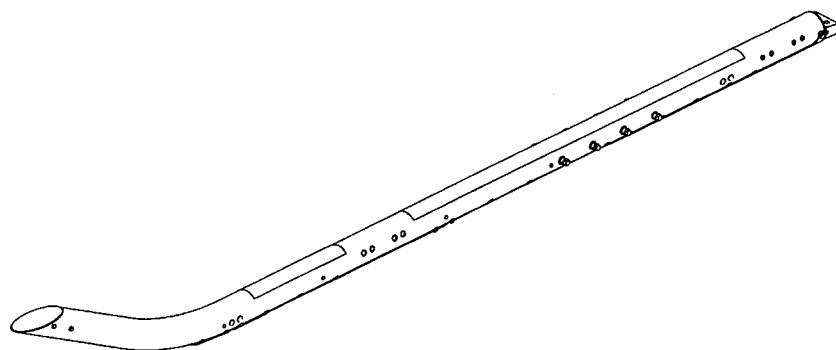
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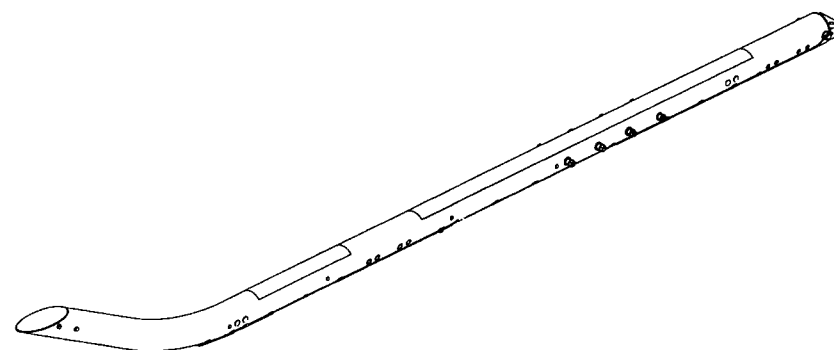
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O 57390



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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08-09-22/11

DESIGN	PD	DART AEROSPACE USA, INC.	
DRAWN	PD	PORT HADLOCK, WA	
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MFG. APPR.	SA	D2750	SHEET 3 OF 11
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DE APPR.	SA	350 SKIDTUBE ASSEMBLY	NTS
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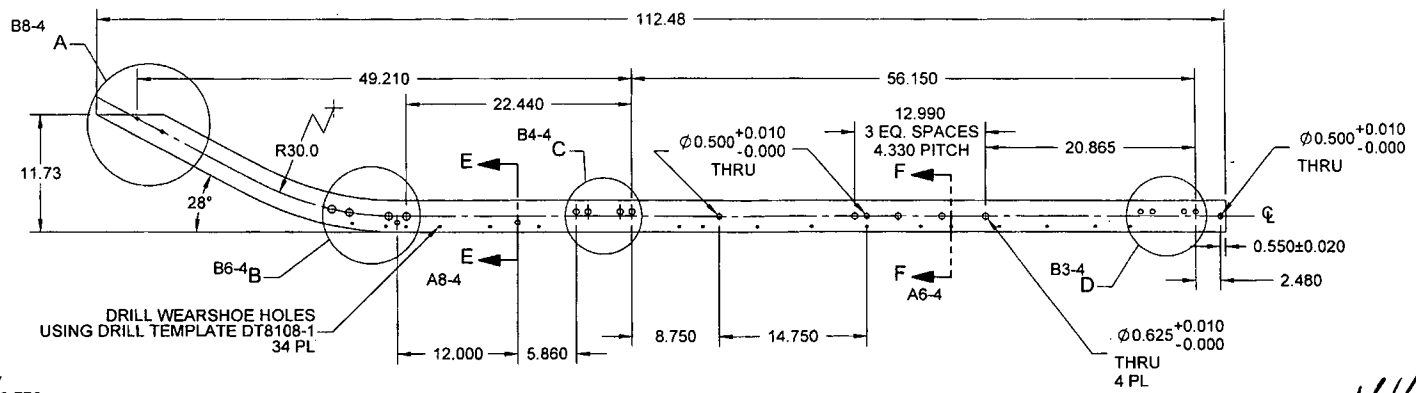
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

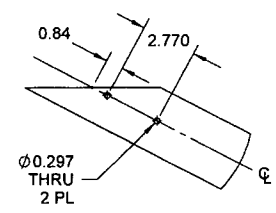
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

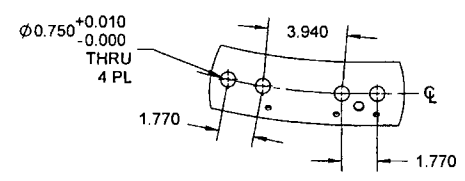


D2750-1 LH SKIDTUBE

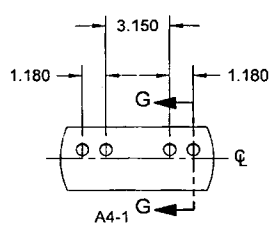
w/o 57390



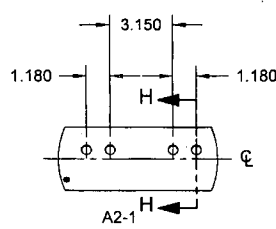
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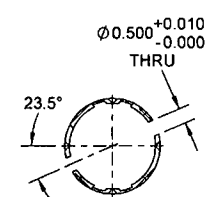
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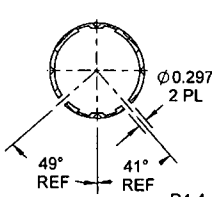
DETAIL C
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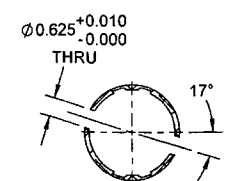
DETAIL D
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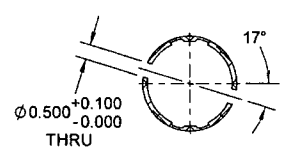
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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08-09-12-18

DESIGN		DART AEROSPACE USA, INC.
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APPROVED		SHEET 4 OF 11
DE APPR.		TITLE 350 SKIDTUBE ASSEMBLY
DATE	08.07.16	SCALE NTS

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Dart Aerospace Ltd

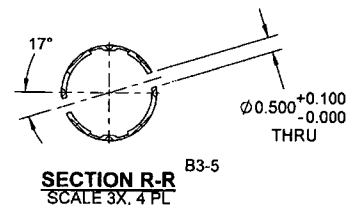
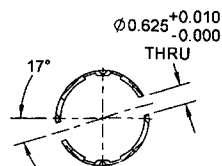
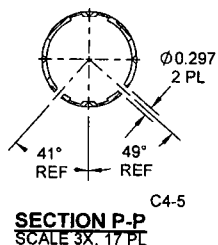
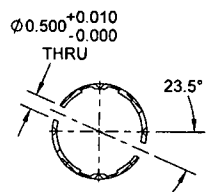
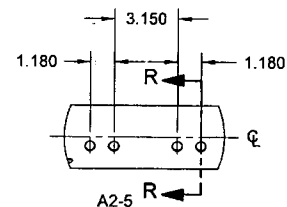
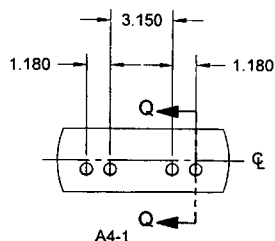
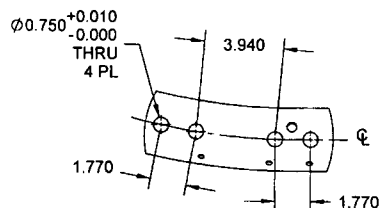
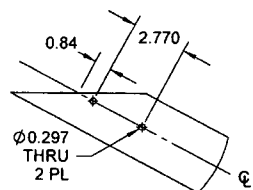
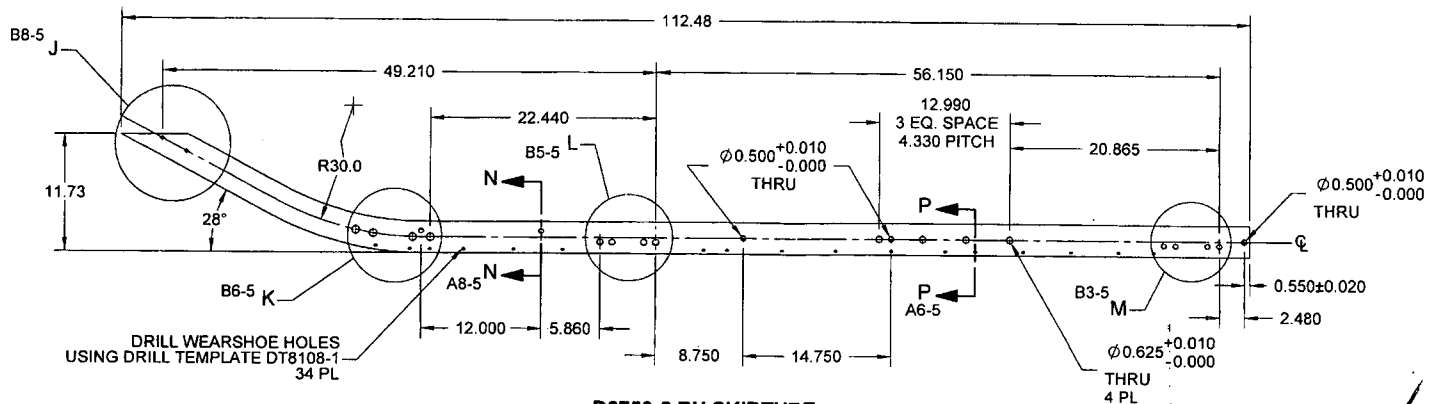
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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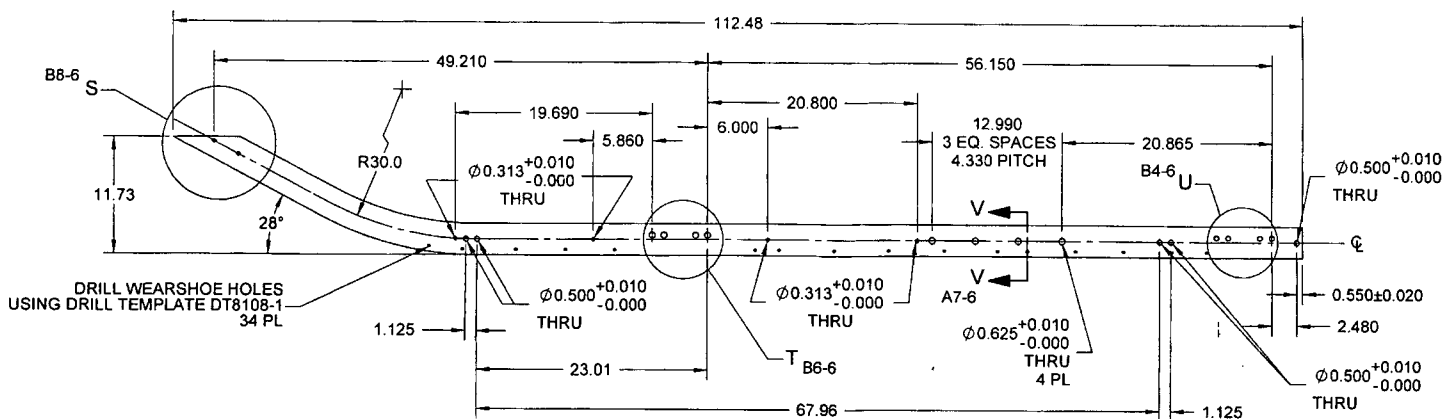
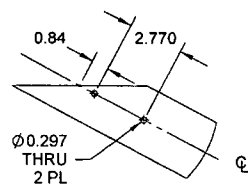
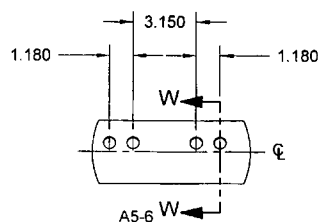
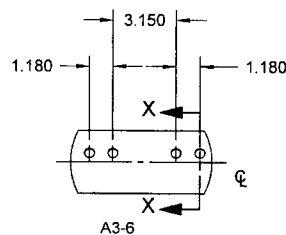
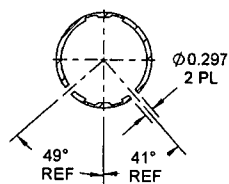
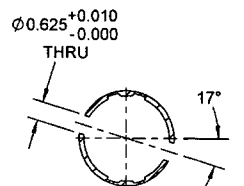
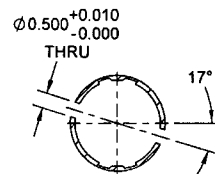
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4

3

2

1

**D2750-3 LH SKIDTUBE****DETAIL S**
D8-6
SCALE 2X**DETAIL T**
C5-6
SCALE 2X**DETAIL U**
D3-6
SCALE 2X**SECTION V-V**
C4-6
SCALE 3X, 17 PL**SECTION W-W**
B6-6
SCALE 3X, 4 PL**SECTION X-X**
B4-6
SCALE 3X, 4 PL

w/o 57390

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08-07-16

DESIGN		DART AEROSPACE USA, INC.
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CHECKED		DRAWING NO. D2750
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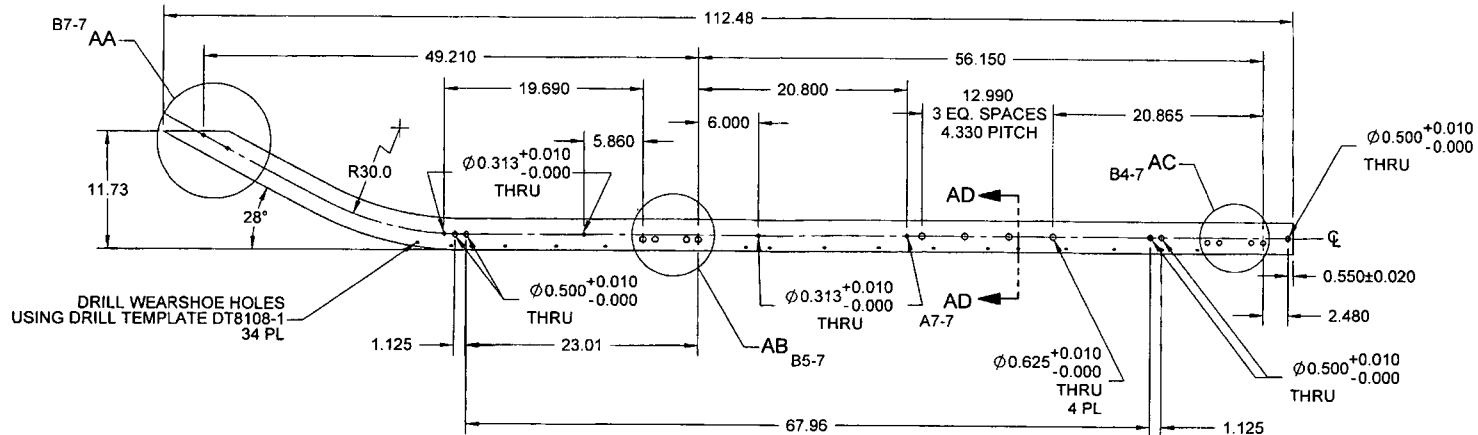
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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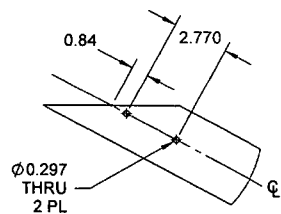
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

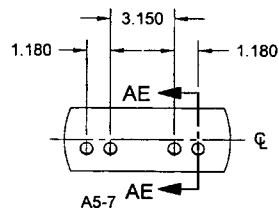
NOTE: Date & initial all entries



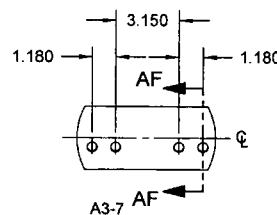
D2750-4 RH SKIDTUBE



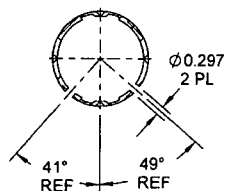
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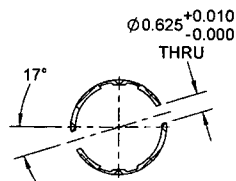
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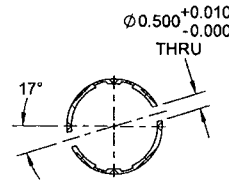
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

WLO 57390

RELEASED
08-29-76

DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
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MFG. APPR.	PA	D2750	SHEET 7 OF 11
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DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
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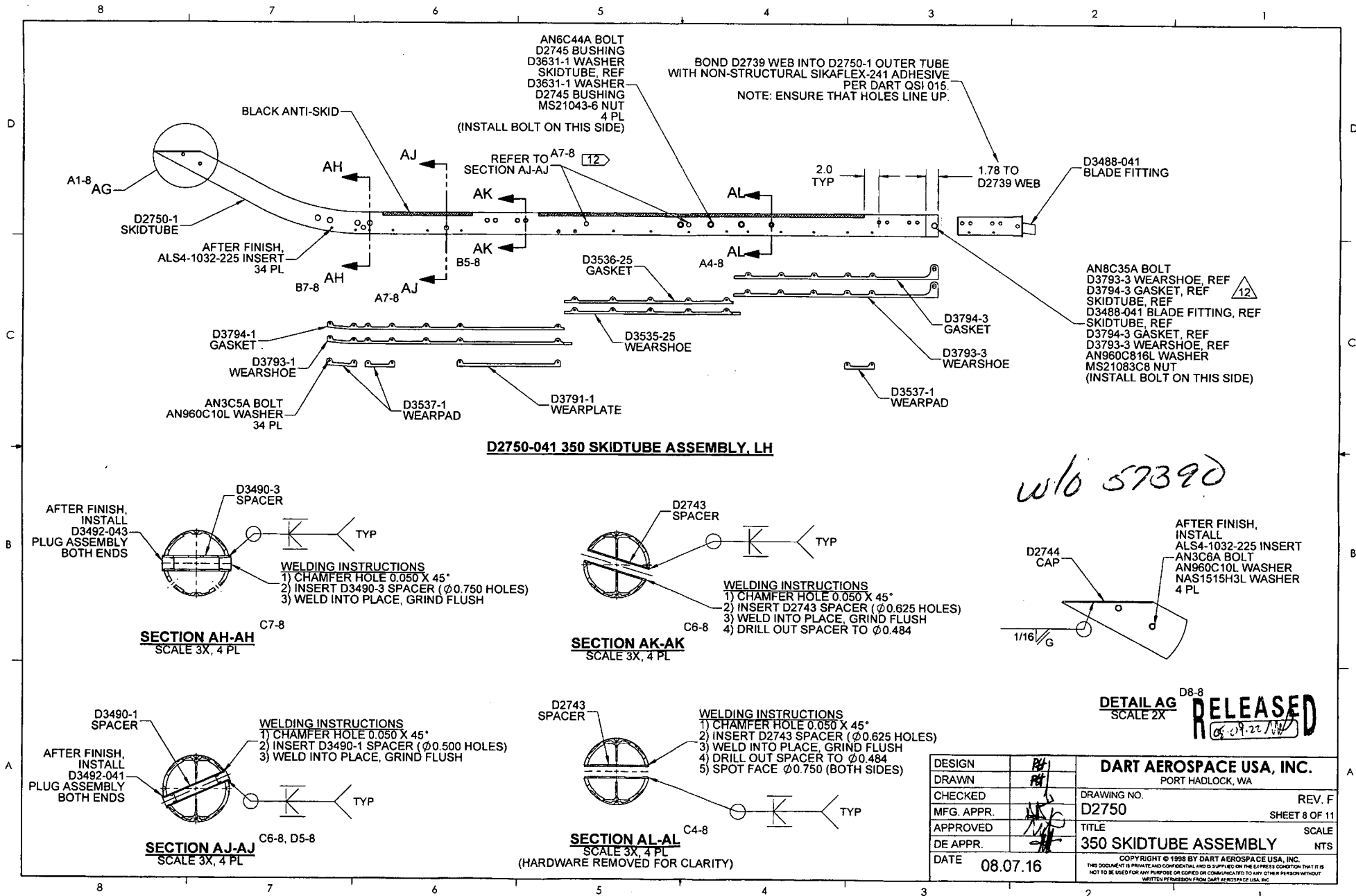
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



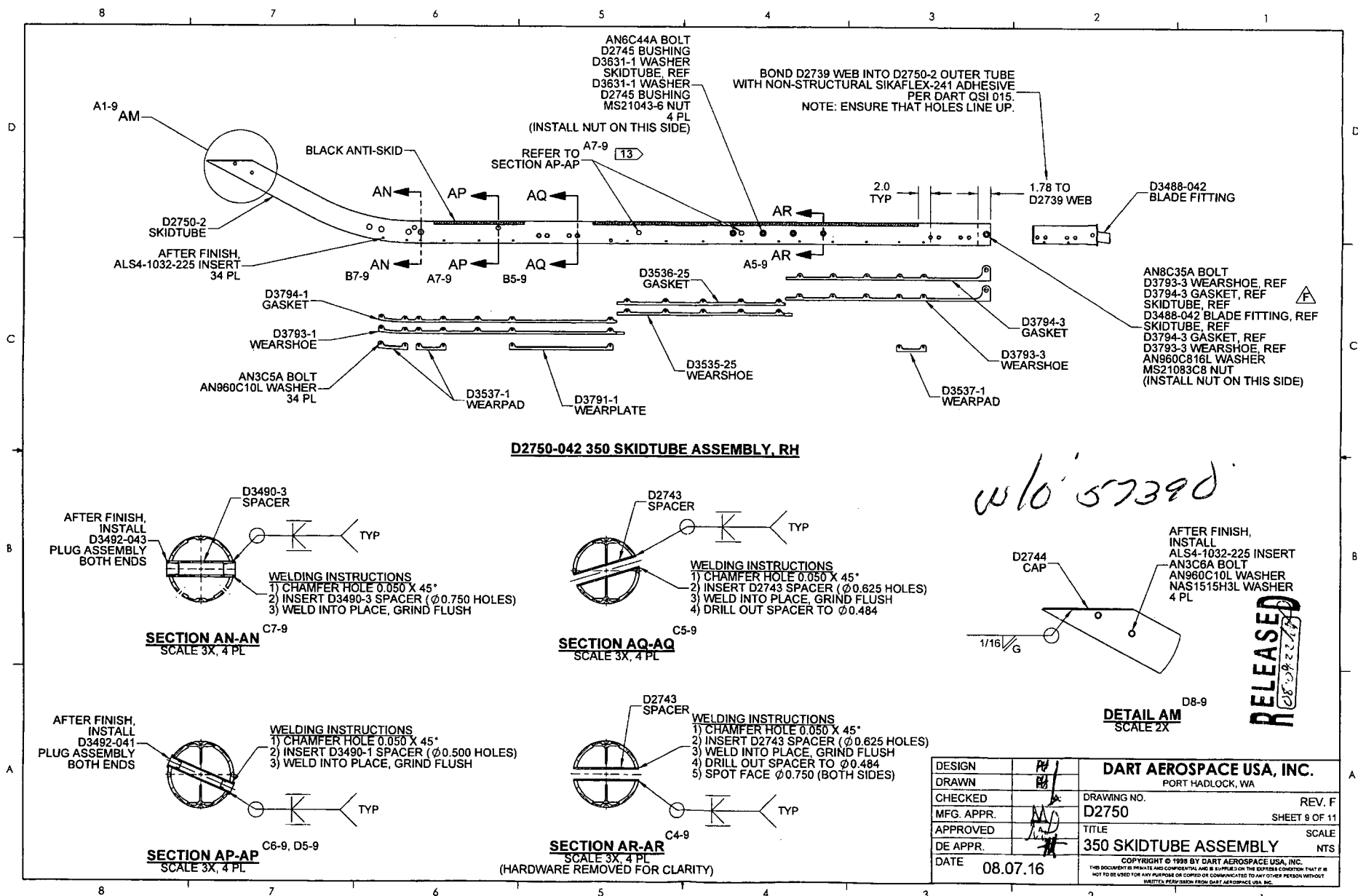
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



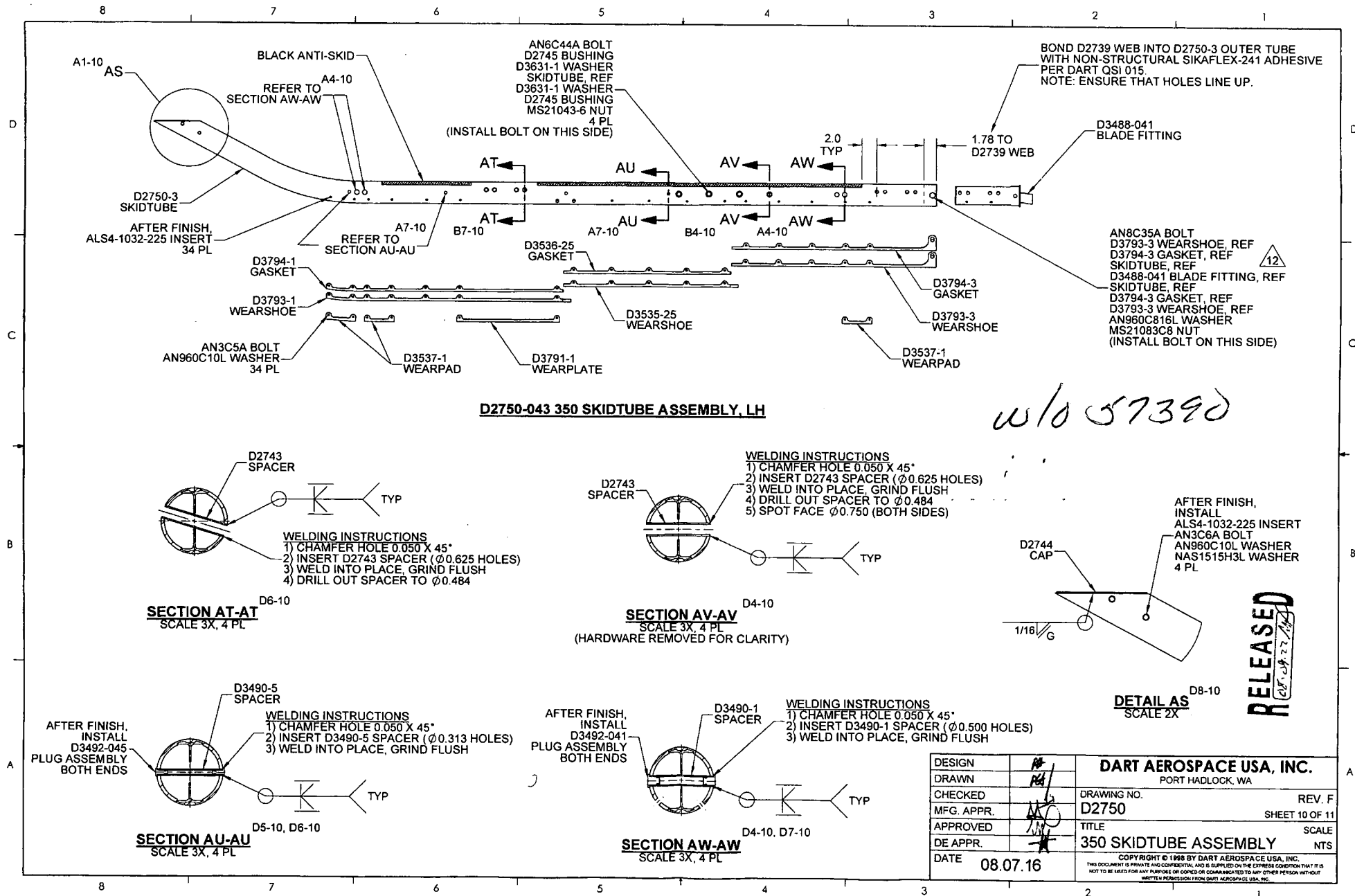
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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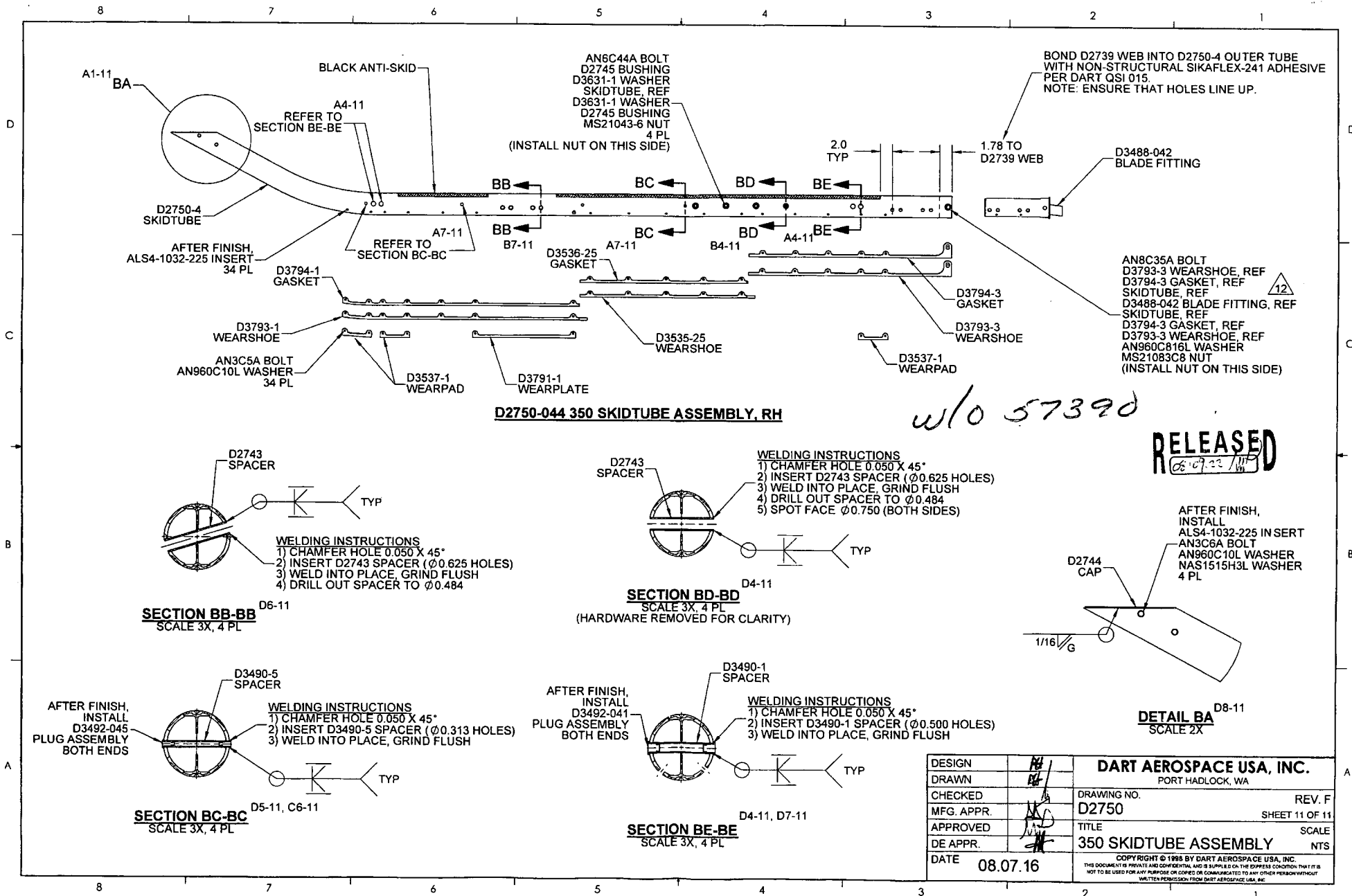
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 225

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 56276
Part number: DSSC-62-03
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. D. A. Date of Test Coupon 10.02.19

Welder Barclay Elliott Date of Test Coupon 16.02.19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld